

Date: Tuesday, 9/25/2007 10:11:43 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34841  
Estimate Number : 10913  
P.O. Number :  
This Issue : 9/25/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LARGE FAB ASSY  
Previous Run : 32891  
Written By :  
Checked & Approved By :  
Comment : Est A 05.09.01 New issue KJ/JLM

Drawing Name : LUG ASSEMBLY  
Part Number : D3405043  
Drawing Number : D3405 REV A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 10/10/2007 Qty: 16 Um: Each

29

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 2.5872 sf(s)

304/316 .125 Sheet

(M304S11GA)

Batch: 104934

IB 07-10-2

5.1744

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: A

Prog Rev: A

IB 07-10-2

2-Deburr if necessary

IB 07-10-2

32

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Enochley

counter

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

IB 07/11/07 32

IB 07/11/07 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: *20x (total 20)*

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

GHW Lug

Pick:

Qty

Part number

Description Batch

\*1

D3404-1

Lug

Handwritten: *B341849 → 20x (total 20)*

AVR

SS Rod

Handwritten: *M106115*

Handwritten: *08/01/29 (20x)*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

Handwritten: *08/01/29 (20x)*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: *08/01/29 (20)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: *08/01/29 (20)*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: *M 106379*

Handwritten: *BK 08-01-30*

Handwritten: *(20)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: *m-b 08/01/30 (20x)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Handwritten: *475*

Handwritten: *8/1/31 50 (20x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01-30	7	restock balance of 83405-3 x 9	LC	08-01-31	9	LC	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: LUG ASSEMBLY

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Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

208/01/31

Job Completion



W 8-1-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

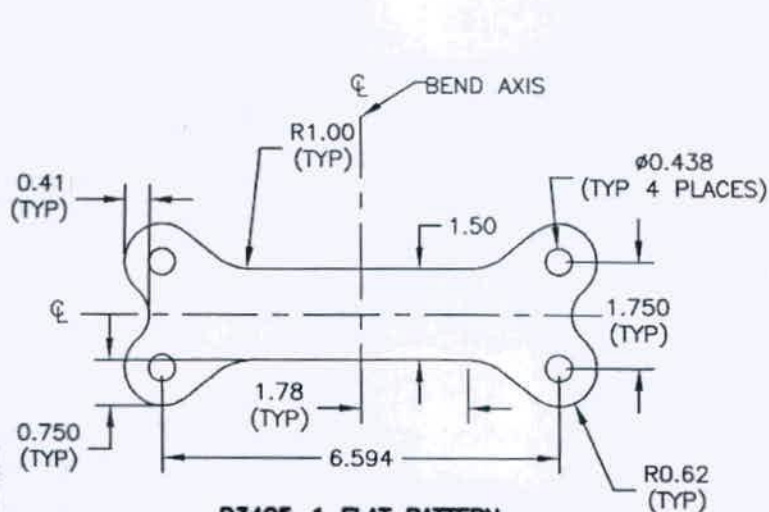
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

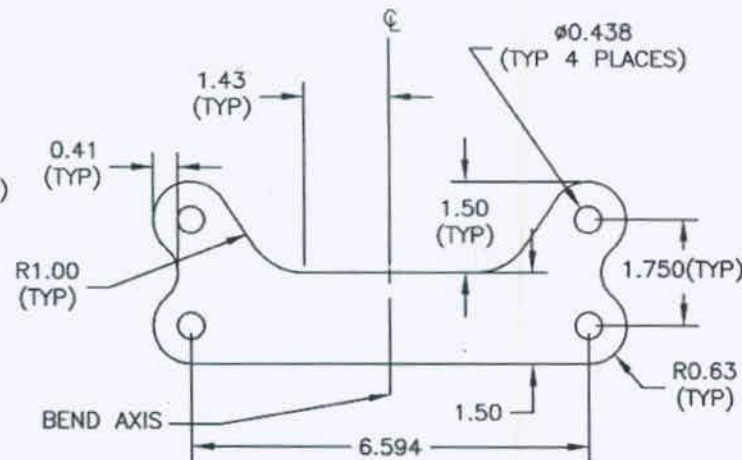
NOTE: Date & initial all entries

**DART**

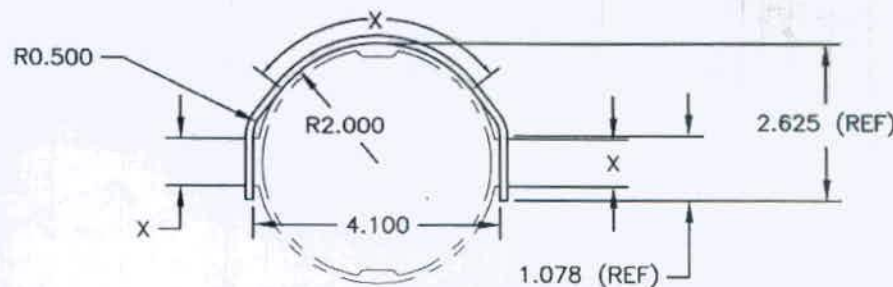
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	TITLE	D3405	REV. A
			GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



**D3405-1 FLAT PATTERN**  
(SYMMETRIC ABOUT CENTERLINES)



**D3405-3 FLAT PATTERN**  
(SYMMETRIC ABOUT CENTERLINES)



**D3405-1 AND D3405-3 BEND DETAIL**  
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

**D3405-1/3 GHW BRACKET**

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 34841





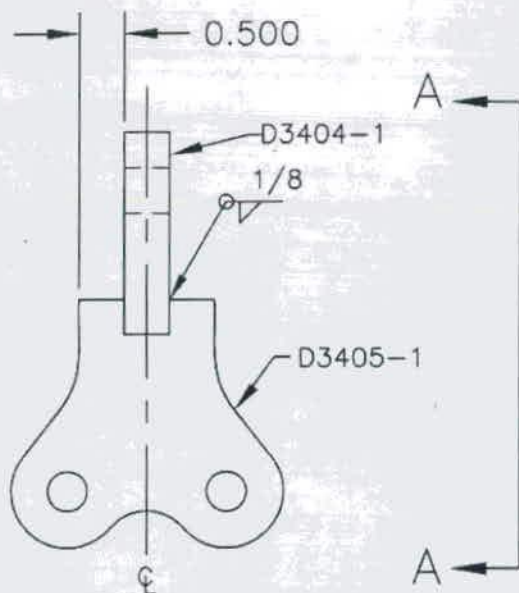
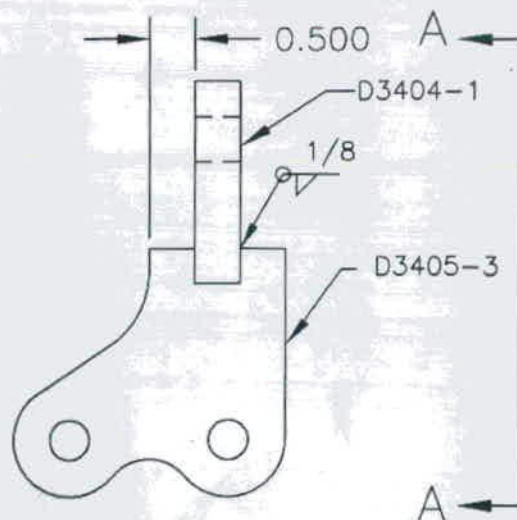




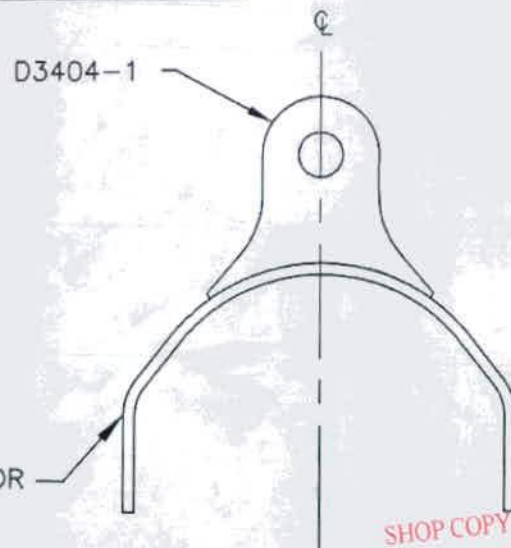


**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

**RELEASED**  
05 08 09 *[Signature]***VIEW A-A****D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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